

Date: Friday, 01/05/2009 11:20:17 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WHEEL ASSEMBLY
 Job Number : 47656
 Estimate Number : 12102
 P.O. Number :
 This Issue : 01/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 37614
 Part Number : D33975
 Drawing Number : D3397 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 30/05/2009 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : J2009.05.01
 Comment : est rev. A New issue EC
 Est Rev:B Now on Doosan Lathe 08-04-01 JLM Verified
 By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1020TR1375W125 ROUND TUBE 1.375 x .125w



Comment: Qty.: 0.1313 f(s)/Unit Total: 2.6250 f(s) 1020
 AISI 1020-1025 ROUND TUBE
 Dia. 1.375" x 0.125" wall batch: M107934

mk 09/05/05

(20)

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA734 Rev NA & Dwg D3397 Rev: A

2-Deburr per dwg D3397

mk 09/05/05

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/05/05

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 09/05/06

(20)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MISC

mk 09.05.06

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WHEEL ASSEMBLY

Job Number: 47656

Part Number: D33975

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/07 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

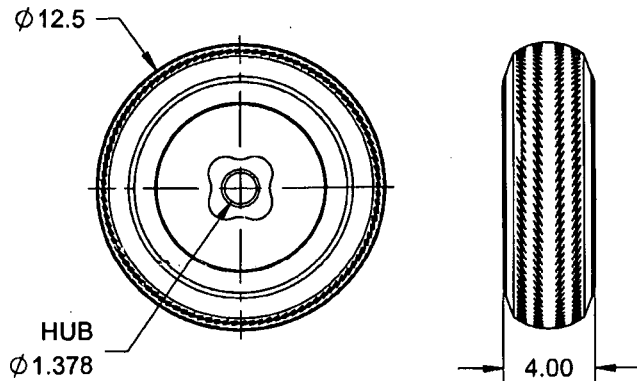
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

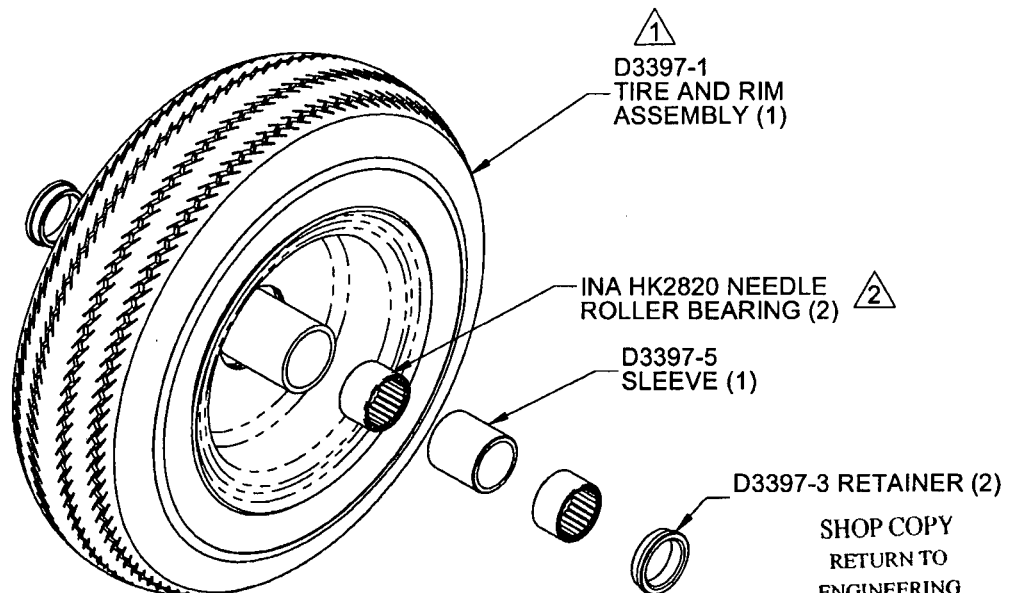
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3397	REV. A SHEET 1 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:8
A	05.02.10	NEW ISSUE	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATATION LOAD
TIRE: $\phi 12.4 \times 4.1$ RIM: $\phi 6.0 \times 4.0$	445 LBS	50 PSI*

1 D3397-1 TIRE AND RIM ASS'Y

RELEASED
[Signature]



D3397-041 WHEEL ASS'Y

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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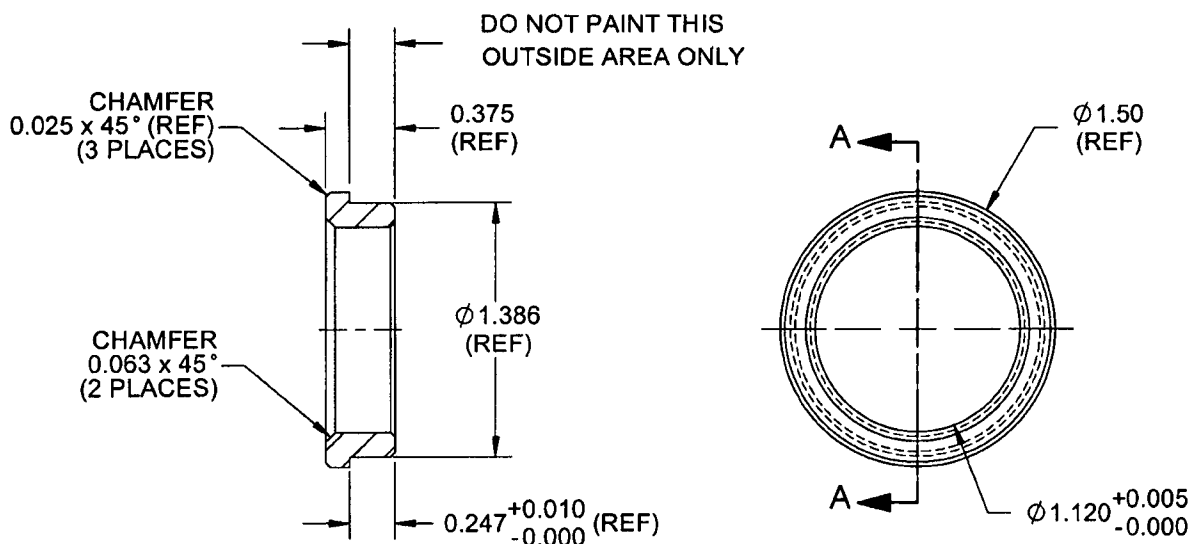
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DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

RELEASED
06/03/09
[Signature]

SPECIFICATION CONTROL DRAWING



SECTION A-A

D3397-3 RETAINER

NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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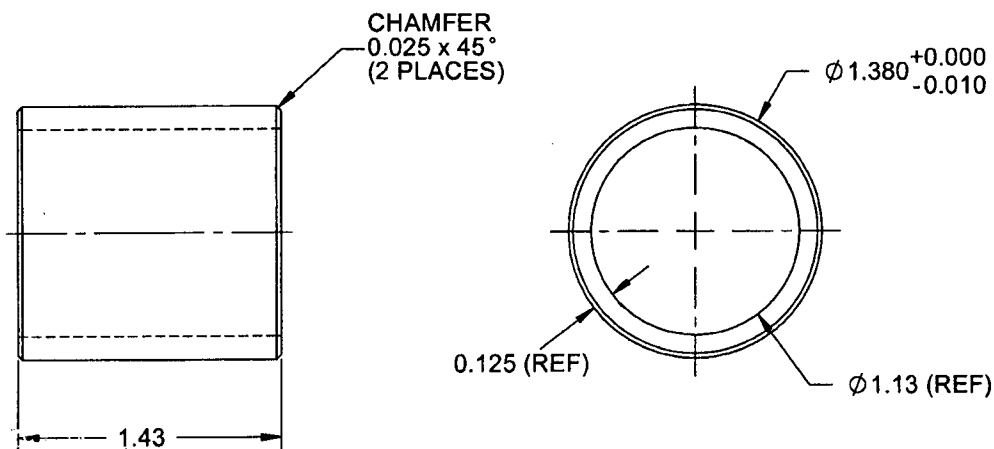
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DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
06/05/09



D3397-5 SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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